

Date: Wednesday, 5/31/2006 7:39:01 AM  
 User: Kim Johnston

## Process Sheet

24

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET QUICK REALEASE 350/355  
 Job Number : 27294  
 Estimate Number : 10241  
 P.O. Number : N/A Part Number : DSI 9052011  
 This Issue : 5/31/2006 S.O. No. : N/A Drawing Number : DSI 9052 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : D  
 Previous Run : 26716 Material : N/A  
 Due Date : 6/12/2006 Qty: 10 Um: Each  
 Written By : See Comment Below  
 Checked & Approved By : 06.05.31  
 Comment : Est Rev: A 02.05.15 New Issue NG

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
 Photocopy bluefile & type labels per PPP 9052-011 CHG001

KS 06.06.01 (10)

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

3.0 BLRS010 Pip Pin



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 BLRS-010

Quick Release Pin (1" grip)

M16557 X10 ✓

M101188 X 23 ✓  
 M100065 X 7 ✓

AL 06/06/06 (10)

4.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/06/06 (10)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D9052-011

Location: FG46 N/A

06/06/06 (10)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ~~Yes~~ Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:39:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET QUICK REALEASE 350/355

Job Number: 27294

Part Number: DSI 9052011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/08

Job Completion



u 06/06/08  
(

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



|                  |               |  |                        |
|------------------|---------------|--|------------------------|
| DESIGN<br>#      | DRAWN BY<br># | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br># | DRAWING NO.<br>DSI 9052                                  | REV. D<br>SHEET 1 OF 1 |
| DATE<br>04.03.23 |               | TITLE<br>QUICK PIN REPLACEMENT                           | SCALE<br>NTS           |
| A                | 96.11.04      | NEW ISSUE  |                        |
| B                | 96.11.13      | ADD PART NUMBERS   |                        |
| C                | 03.12.11      | ADD DSI 9052-013   |                        |
| D                | 04.03.23      | ADD CLAMPS ONLY NOTE                                     |                        |

## **DART SERVICE INSTRUCTION**

**TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F**  
(REF. CANADIAN STC: SH94-14, REF. FAA STC: SR00213NY)  
**AND TO AMEND INSTALLATION DRAWING D350-602 REV. D**  
(REF. CANADIAN STC: SH93-97, REF. FAA STC: SR01144NY)

**PURPOSE: TO ALLOW SUBSTITUTION OF THE BASKET/POD ATTACHMENT BOLTS WITH QUICK RELEASE PINS**

THE AN4-12A & AN4-16A BOLTS USED ON D2230-1 CLAMPS MAY BE REPLACED WITH STAINLESS STEEL POSITIVE LOCKING QUICK RELEASE PINS WITH A MINIMUM DOUBLE SHEAR STRENGTH OF 2400 LBS AND 0.25 INCH DIAMETER.

| BOLT    | MIN GRIP | POSSIBLE QUICK RELEASE PIN REPLACEMENT   |
|---------|----------|--|
| AN4-12A | 1.0"     | AVIBANK: BLC4B10S, BLC4TA10S, BLC4R10S, BLC4LA10S<br>MS NUMBER: MS17984C410, MS17985C410, MS17986C410, MS17987C410<br>REID: BLRS-010, BLBS-010 |
| AN4-16A | 1.3"     | AVIBANK: BLC4B13S, BLC4TA13S, BLC4R13S, BLC4LA13S<br>MS NUMBER: MS17984C413, MS17985C413, MS17986C413, MS17987C413<br>REID: BLRS-020, BLBS-020 |

THE FOLLOWING OPTIONAL KITS ARE AVAILABLE FROM DART TO PROVIDE QUICK RELEASE CAPABILITY:

| QTY<br>-011 | QTY<br>-013 | PART NUMBER  | DESCRIPTION  |
|-------------|-------------|--------------|--|
| X           |             | DSI 9052-011 | QUICK RELEASE KIT, FOR D350-607-041/-043/-045/-047 |
|             | X           | DSI 9052-013 | QUICK RELEASE KIT, FOR D350-602-011                |
| 4           | 1           | BLRS-010     | QUICK RELEASE PIN (1" GRIP)                        |
|             | 3           | BLRS-020     | QUICK RELEASE PIN (1.5" GRIP)                      |

IT IS ACCEPTABLE TO LEAVE THE D2230-1/-3 CLAMPS INSTALLED ON THE CROSSTUBES WHEN THE UNCONTROLLED COPY BASKET OR POD IS REMOVED.

WEIGHT & BALANCE, FOR CLAMPS ONLY, IS 1.8lb (0.82kg) @ STA 135in (3.43m) & BL ±36in (±0.91m).

SHOP COPY  
RETURN TO  
ENGINEERING

SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 27294

|  |  |
|--|--|
| CANADA<br>DEPARTMENT OF TRANSPORT<br>AIRCRAFT CERTIFICATION<br>BRANCH<br>DAO # 01-O-01 |  |
| APPROVED   |  |
| BY:  |  |
| D. SHEPHERD (DE # 02)  |  |
| DATE: 04.03.23   |  |
| CERT. NO.: SH94-14   |  |
| ISSUE NO.: 4   |  |

|  |  |
|--|--|
| CANADA<br>DEPARTMENT OF TRANSPORT<br>AIRCRAFT CERTIFICATION<br>BRANCH<br>DAO # 01-O-01 |  |
| APPROVED   |  |
| BY:  |  |
| D. SHEPHERD (DE # 02)  |  |
| DATE: 04.03.23   |  |
| CERT. NO.: SH93-97   |  |
| ISSUE NO.: 3   |  |

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